

# Work Order ID 64574

Wednesday, December 08, 2010 10:29:50 A



Page 1

Item ID: D3805-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: <del>State</del>					
Start Date: 12/8/2010	Start Qty: 6.00		Cust Item ID:		
Required Date: 12/22/2010	Req'd Qty: 6.00		Customer:		

## Reference:

Approvals:	Process Plan: <u>PL</u>	Date: <u>10-12-8</u>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D3805	Rev A								
100		0.00							
Waterjet	<b>Memo</b>	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3805								
304 .050	Dwg Rev: <u>A</u>								
	Prog Rev: <u>A</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
QC	<b>Memo</b>	0.00							
Quality Control									

1810-12-17

(6)

1810-12-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64574**

Wednesday, December 08, 2010 10:29:50 A



Page 2

Item ID: D3805-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 12/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00				(46)			
130  Brake NC Brake NC	Memo Form as per Dwg D3805 using Jigs DT8261 and DT8326	0.00 0.00				(6)			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00				(46)			

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**Work Order ID 64574**

Wednesday, December 08, 2010 10:29:50 A



Page 3

Item ID: D3805-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Plate

Start Date: 12/8/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 12/22/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  Packaging Packaging	Identify as per dwg & Stock Location: <i>WA</i>  Memo	0.00  0.00				<i>Q</i>	<i>11-4-12</i>	<i>X6</i>	
160  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<i>11/4/13</i> <i>11-04-13</i> <i>(4)</i>

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, December 08, 2010 10:29:54 AM

Page 1

Work Order ID: 64574

Parent Item: D3805-1

Parent Item Name: Plate



Start Date: 12/8/2010

Required Date: 12/22/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-15 new issue DD verified by:EC  
 IPP Rev:B 08-07-30 redesign flat pattern DD verified by:EC  
 IPP Rev:C 08-09-23 redesign flat pattern DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M304S18GA

Purchased

No

100

sf

122.6200

3.8542

24.34232



304/316 .050 Sheet



1810-12-17

Location

Loc Qty

Loc Code

MAT

96

116135

96

MAT20

26.62

111743

4.75

113062

20.77

115389

1.1

116135

(6)

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**NOTE:** Date & initial all entries





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**NOTE:** Date & initial all entries

8

7

6

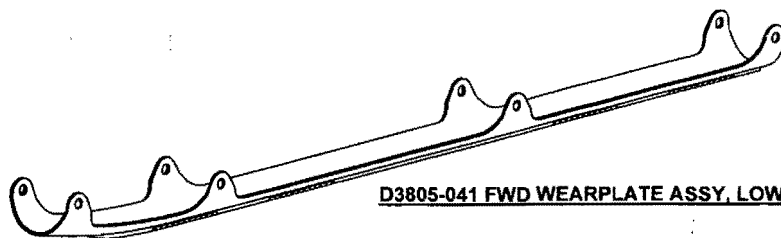
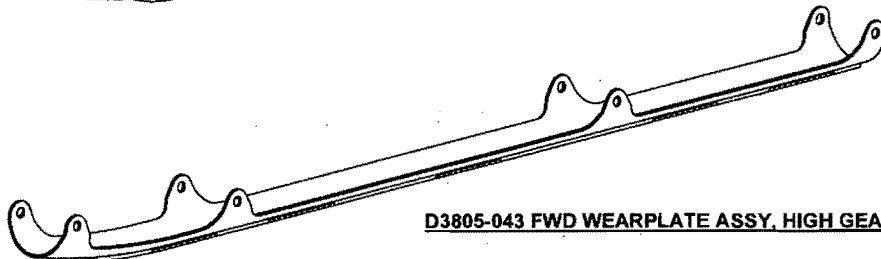
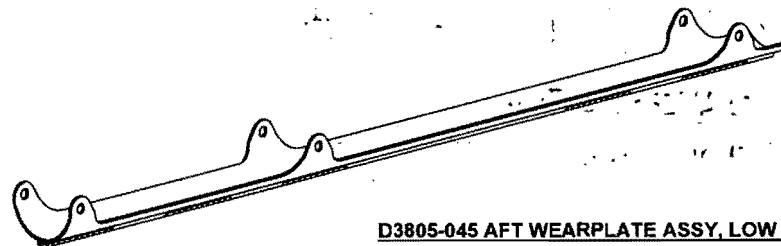
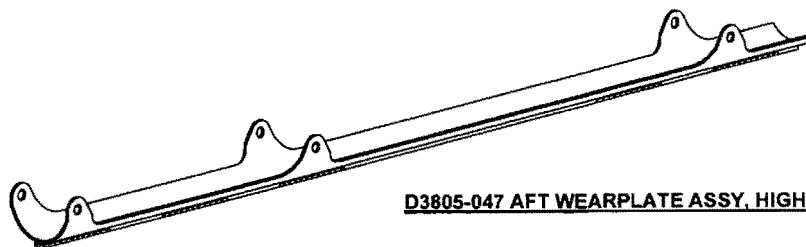
5

4

3

2

1

**D3805-041 FWD WEARPLATE ASSY, LOW GEAR****D3805-043 FWD WEARPLATE ASSY, HIGH GEAR****D3805-045 AFT WEARPLATE ASSY, LOW GEAR****D3805-047 AFT WEARPLATE ASSY, HIGH GEAR**

ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3805-041	FWD WEARPLATE ASSY, LOW GEAR
2		X			D3805-043	FWD WEARPLATE ASSY, HIGH GEAR
3			X		D3805-045	AFT WEARPLATE ASSY, LOW GEAR
4				X	D3805-047	AFT WEARPLATE ASSY, HIGH GEAR
11	1				D3805-1	PLATE
12		1			D3805-3	PLATE
13			1		D3805-5	PLATE
14				1	D3805-7	PLATE
15	1				D3806-1	BAR
16		1			D3806-3	BAR
17			1		D3806-5	BAR
18				1	D3806-7	BAR
19	1				D3807-1	GASKET
20		1			D3807-3	GASKET
21			1		D3807-5	GASKET
22				1	D3807-7	GASKET
31	A/R	A/R	A/R	A/R	2059B	HARDCOAT
32	A/R	A/R	A/R	A/R	1300 (OR 1300L)	3M SCOTCH-GRIP ADHESIVE

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 041574  
2810-12-8

**RELEASED**  
4P 09.03.03  
Per ECN 09-538

A	NEW ISSUE	MB	08.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>JS</i>	PORT HADLOCK, WA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D3805	SHEET 1 OF 8
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEARPLATE ASSY	NTS
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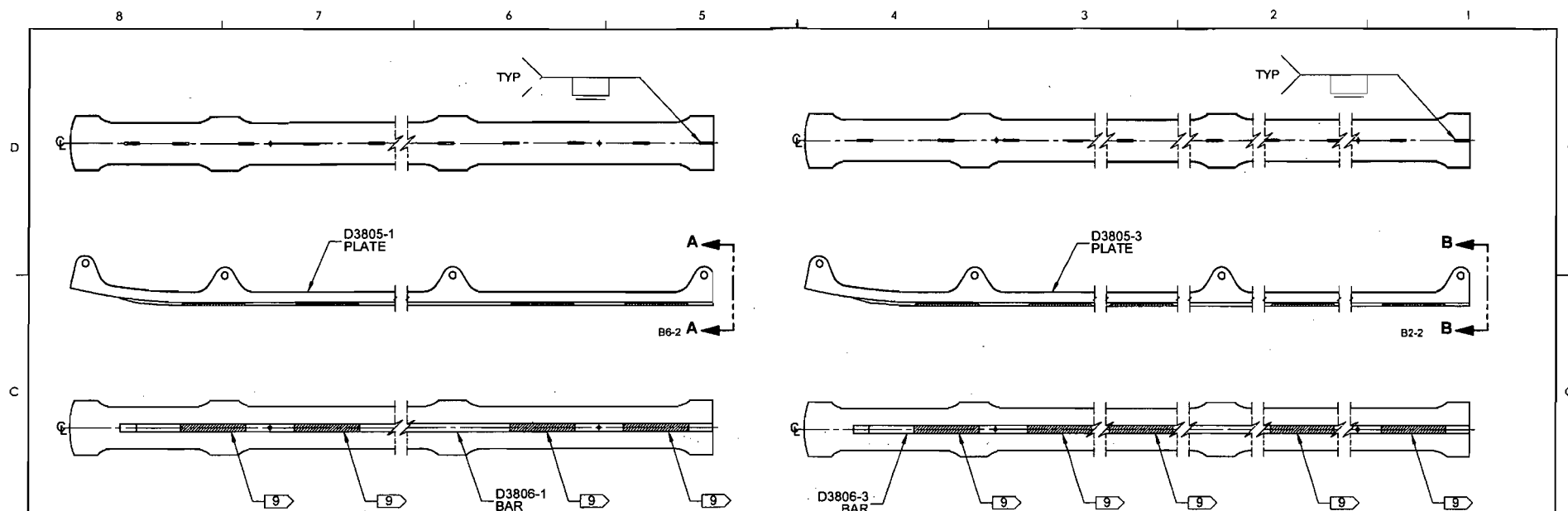
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

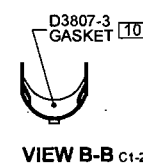
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**NOTE:** Date & initial all entries



**D3805-041 FWD WEARPLATE ASSY, LOW GEAR**

**D3805-043 FWD WEARPLATE ASSY, HIGH GEAR**



W1064574

**RELEASED**  
09.03.23

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3805-04X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D3805-041 = 3.79 lbs; D3805-043 = 4.36 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.19 THICK X 0.50 WIDE, FLUSH WITH D3806-X BAR ON ALL 3 SURFACES
- 10) AFTER FINISH, BOND D3807-X GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

DESIGN	JP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	AS	D3805	SHEET 2 OF 8
APPROVED	JP	TITLE	SCALE
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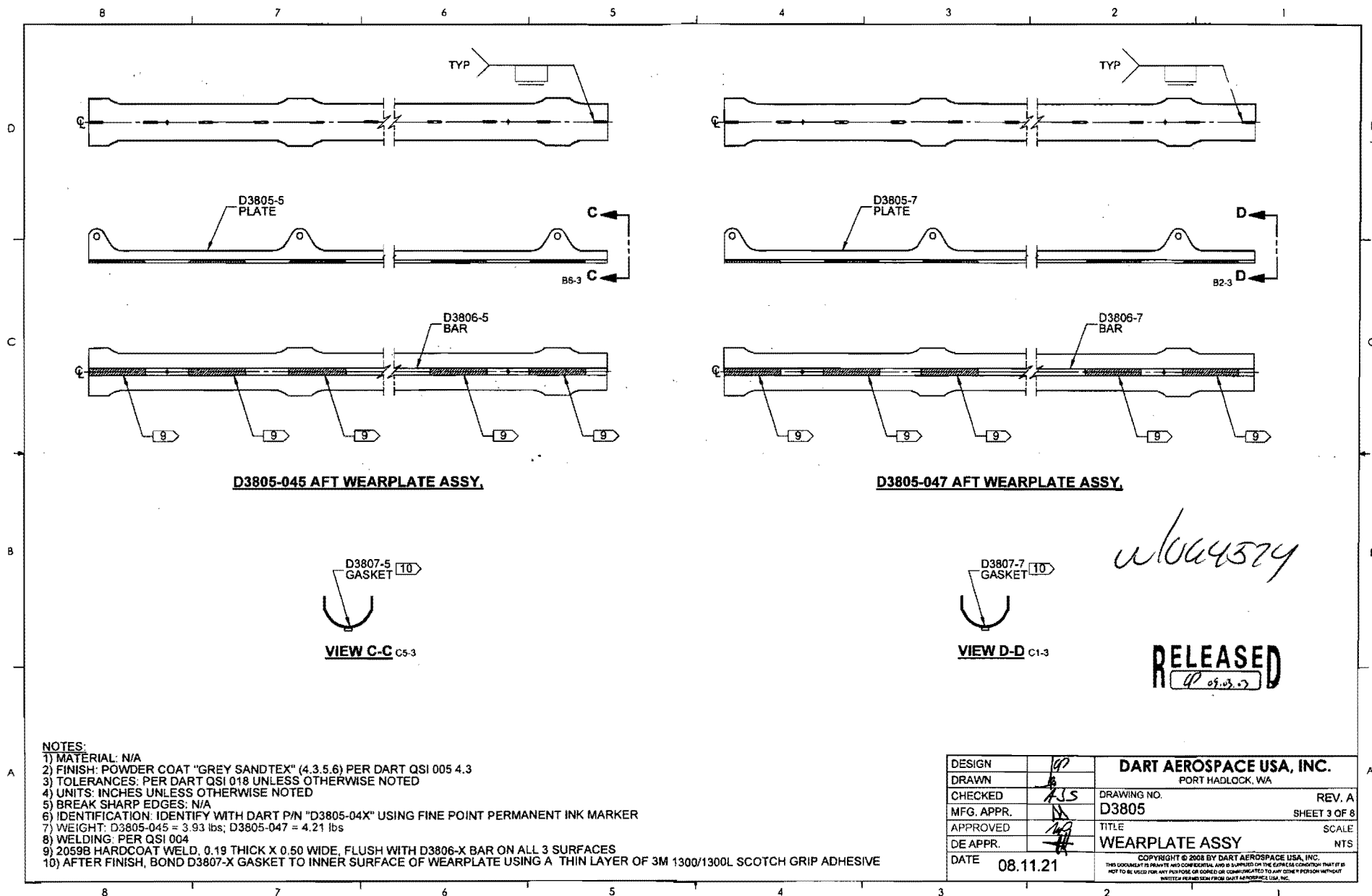
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



DESIGN	107	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	107	PORT HADLOCK, WA	
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MFG. APPR.	107	D3805	SHEET 3 OF 8
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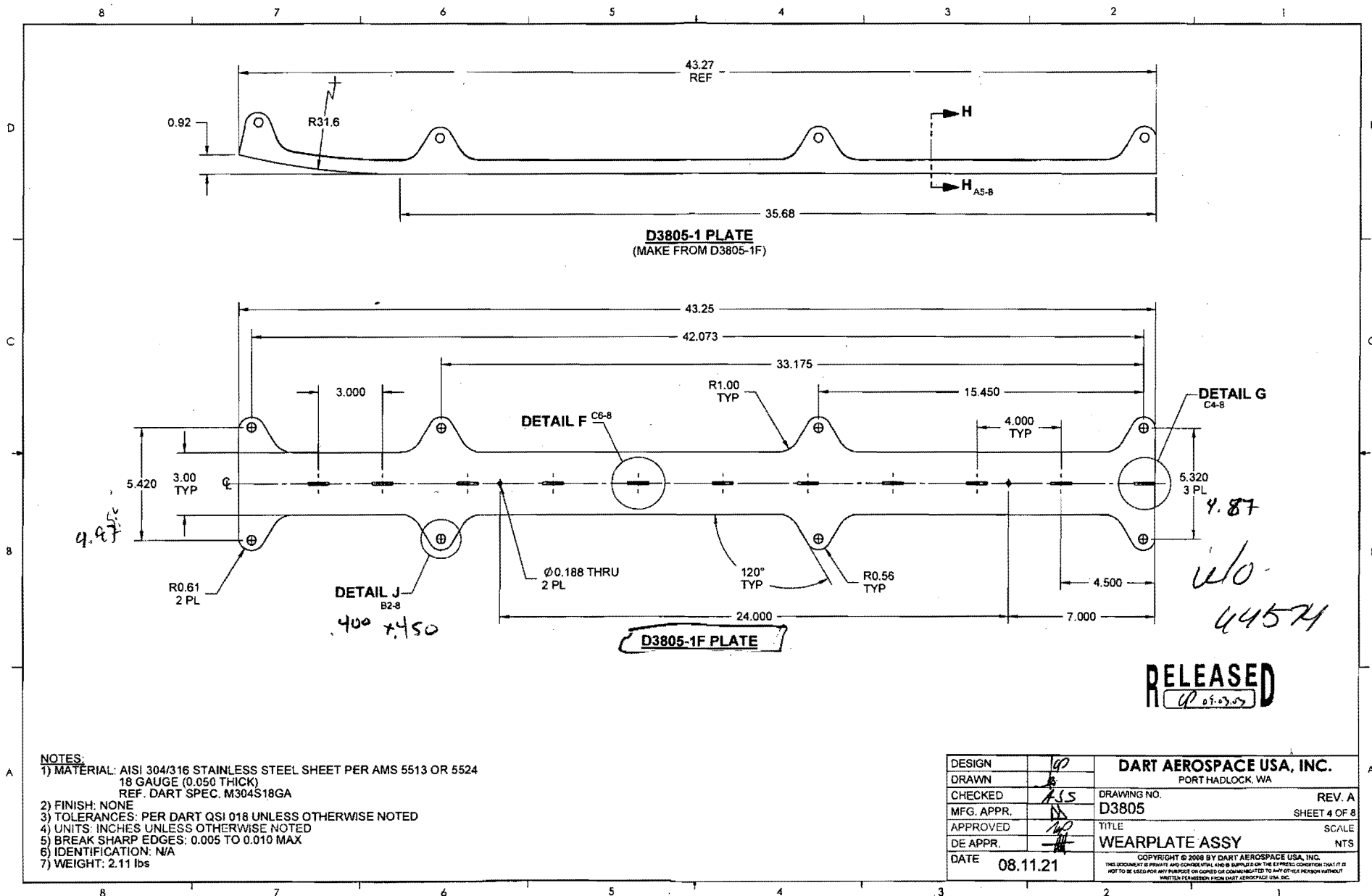
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**NOTE:** Date & initial all entries





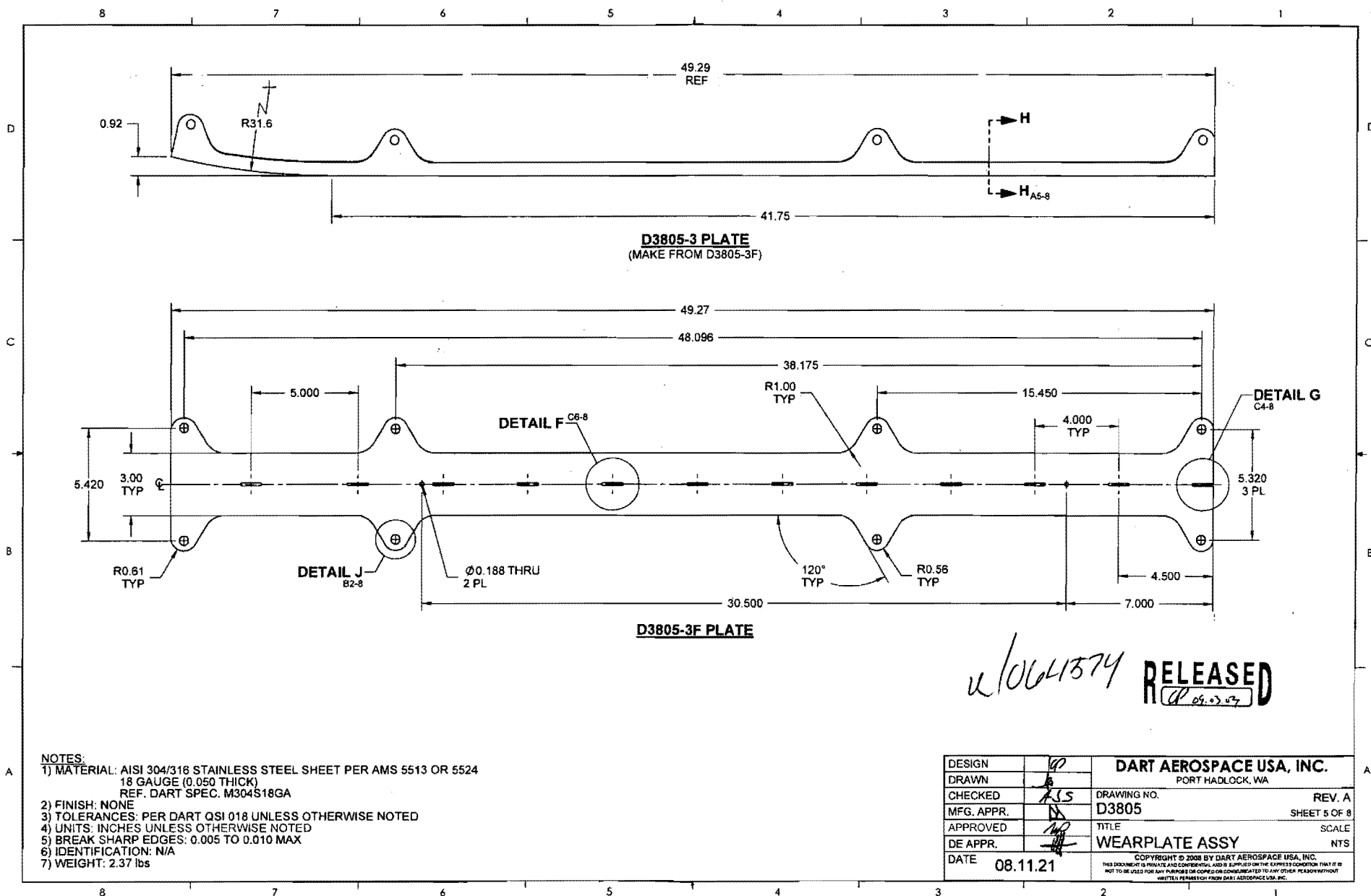
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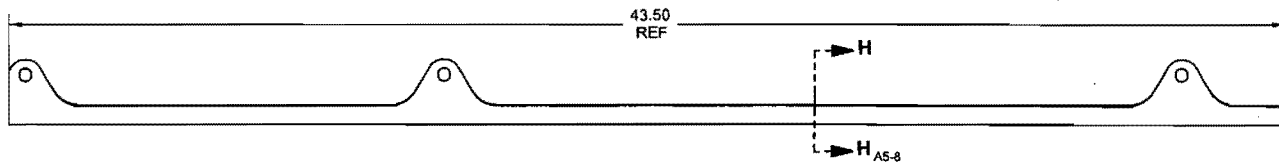
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**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1

D

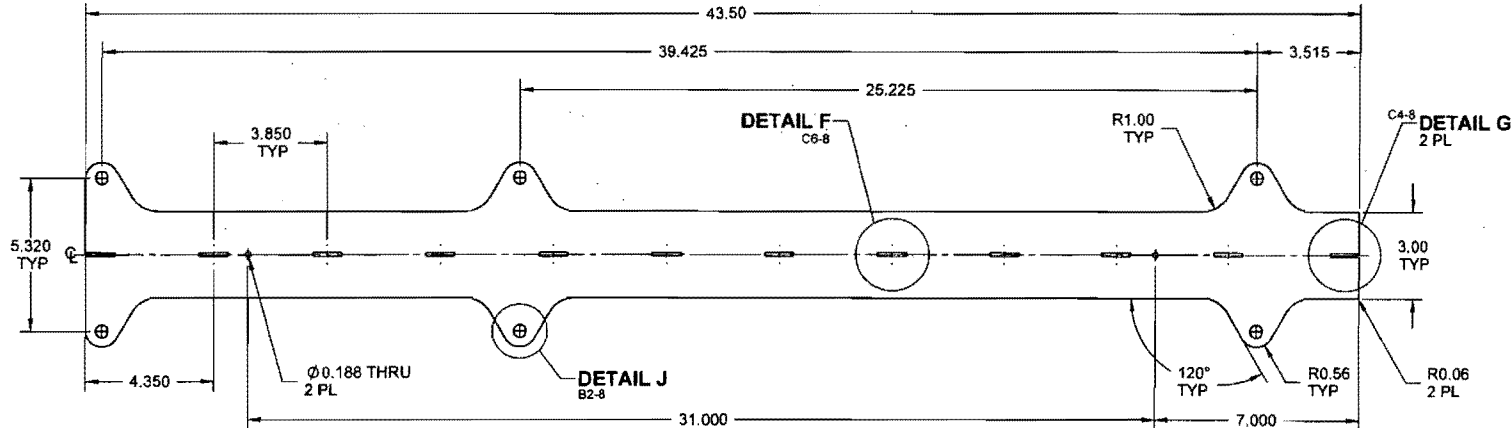
D



**D3805-5 PLATE**  
(MAKE FROM D3805-5F)

C

C



**D3805-5F PLATE**

u1064574 RELEASED  
CP 09-03-07

**NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524  
18 GAUGE (0.050 THICK)  
REF. DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.06 lbs

DESIGN	JP	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JP	PORT HADLOCK, WA	
CHECKED	AS	DRAWING NO.	REV. A
MFG. APPR.	JP	D3805	SHEET 6 OF 8
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8 7 6 5 4 3 2 1

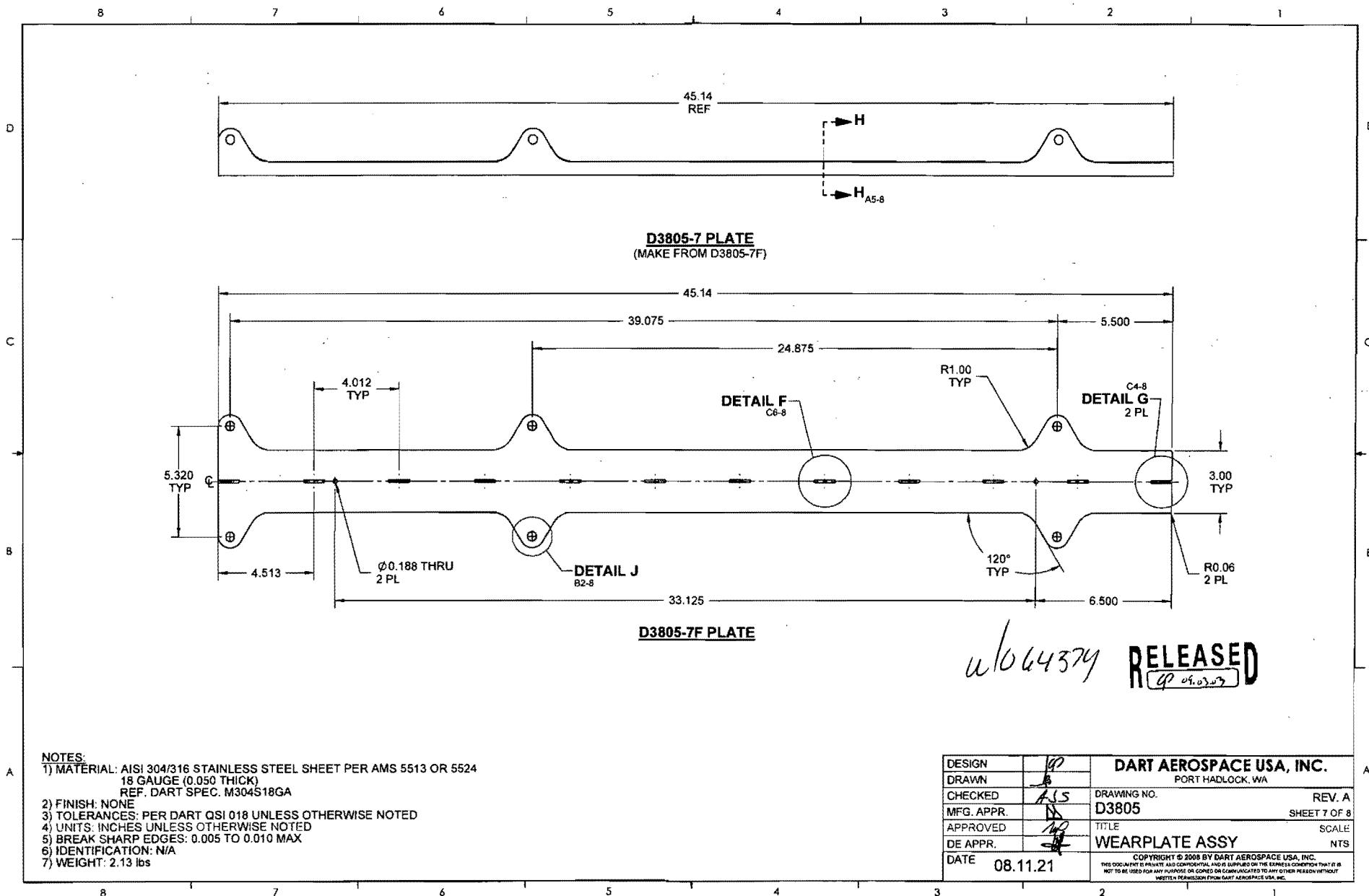
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u1064374 RELEASED  
 09.03.07

W/O:		WORK ORDER CHANGES					
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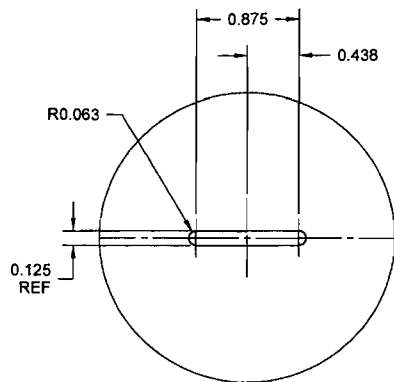
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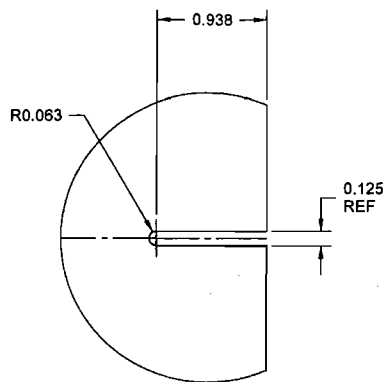
**NOTE:** Date & initial all entries





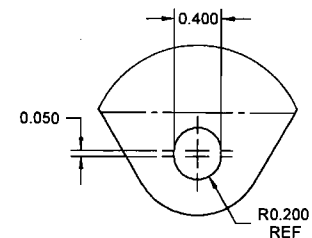
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SLOT DETAIL TYP  
SCALE 4X

C5-4  
C5-6  
C4-6  
C4-7



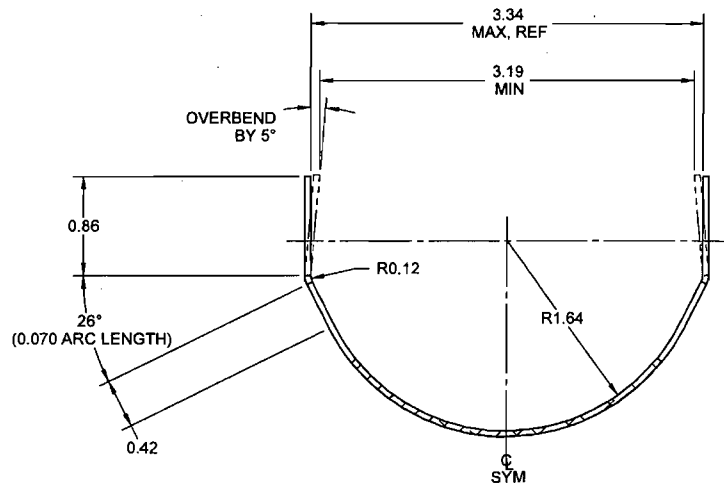
**DETAIL G**  
SLOT DETAIL TYP  
SCALE 4X

C1-4  
C1-5  
C1-6  
C2-7



**DETAIL J**  
SCALE 4X

B6-4  
B7-5  
B5-6  
B5-7



**SECTION H-H**  
SCALE 4X

D3-4  
D3-5  
D3-6  
D3-7

**RELEASED**  
909.03.03

DESIGN	19	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	15	PORT HADLOCK, WA	
CHECKED	15	DRAWING NO. <b>D3805</b>	REV. A
MFG. APPR.	15		SHEET 8 OF 8
APPROVED	15	TITLE <b>WEARPLATE ASSY</b>	SCALE
DE APPR.	15		NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries